

Date: Wednesday, 28/11/2007 2:43:29 PM  
 User: Linda Lacelle

SP/07/12/26

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: HELI-ACCESS STEP RH (FOLDING)	
Job Number	: 33999 - 1		Part Number	: D412630034	
Estimate Number	: 12568		Drawing Number	: IIN UNDER REVIEW	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 28/11/2007 S.O. No. : N/A		Drawing Revision	: K	
Prsh't Rev.	: NC		Material	: N/A	
First Issue	: 16/08/2007 Type : LARGE FAB ASSY		Due Date	: 05/09/2007	
Previous Run	: 33577		Qty:	2 Um: Each	
Written By					
Checked & Approved By					
Comment	: Est. Rev:A New Issue 06-11-08 JLM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	DC	DOCUMENT CONTROL	
		Comment: DOCUMENT CONTROL Photocopy bluefile & create labels per PPP D412-630-034 CHG002	
2.0	D2012107	Clevis	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Clevis Pick: Qty Part Number Description Batch	
		1 D2012-107 Clevis	33383, 50
3.0	D2803042	Bracket Assembly	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Bracket Assembly Pick: Qty Part Number Description Batch	
		1 D2803-042 Bracket Assembly RH	33392, 27283
4.0	D2804042	Bracket Assembly	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Bracket Assembly Pick: Qty Part Number Description Batch	
		1 D2804-042 Bracket Assembly RH	3408, 29409, 7/12/2008

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Drawing Name: HELI-ACCESS STEP RH (FOLDING)

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Seq. #:	Machine Or Operation:	Description :								
5.0	D2807	Gas Spring (Support Prop)								
		 Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) Support Prop Pick: <table> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>2</td> <td>D2807-041</td> <td>Gas Spring</td> <td>35962</td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	2	D2807-041	Gas Spring	35962
Qty	Part Number	Description	Batch							
2	D2807-041	Gas Spring	35962							
6.0	D2813	Washer								
		 Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) Washer Pick: <table> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>2</td> <td>D2813</td> <td>Washer</td> <td>32775</td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	2	D2813	Washer	32775
Qty	Part Number	Description	Batch							
2	D2813	Washer	32775							
7.0	D3562042	STEP ASSEMBLY, RH								
		 Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Step Weldment LH Pick: <table> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D3562-042</td> <td>Step Weldment RH</td> <td>335822</td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	1	D3562-042	Step Weldment RH	335822
Qty	Part Number	Description	Batch							
1	D3562-042	Step Weldment RH	335822							
8.0	D33951	Bushing								
		 Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s) Bushing Pick: <table> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>4</td> <td>D3395-1</td> <td>Bushing</td> <td>33578</td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	4	D3395-1	Bushing	33578
Qty	Part Number	Description	Batch							
4	D3395-1	Bushing	33578							
9.0	AN3C21A	BOLT								
		 Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) BOLT Pick: <table> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>2</td> <td>AN3C21A</td> <td>Bolt</td> <td>3101189</td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	2	AN3C21A	Bolt	3101189
Qty	Part Number	Description	Batch							
2	AN3C21A	Bolt	3101189							

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Job Number:



Seq. #:	Machine Or Operation:	Description :
10.0	AN8C16	Bolt
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)	
	Bolt	
	Pick:	
	Qty Part Number	Description
	2 AN8C16	Bolt
11.0	AN310C8	Nut
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)	
	Nut	
	Pick:	
	Qty Part Number	Description
	2 AN310C8	Nut
12.0	MS24665302	Cotter Pin
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)	
	Cotter Pin	
	Pick:	
	Qty Part Number	Description
	2 MS24665-302	Cotter Pin (or AN380C3-4)
13.0	NAS1515H3	Washer
	Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s)	
	Washer	
	Pick:	
	Qty Part Number	Description
	6 NAS1515H3	Washer
14.0	NAS1515H5L	WASHER
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)	
	WASHER	
	Pick:	
	Qty Part Number	Description
	4 NAS1515H5L	Washer

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Seq. #: Machine Or Operation: Description :

15.0 NAS1515H8 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
4	NAS1515H8	Washer	M1017E1

16.0 MS210433 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
4	MS21043-3	Nut	M1057K2

17.0 MS24693C280 Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Screw

Pick:

Qty	Part Number	Description	Batch
2	MS24693-C280	Screw (or MS24694-C565)	M10139C : 9/10/2007 (2)

18.0 SMALL FAB 1 SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: M104929

COAT exposed HARDWARE WITH LPS PROCYON .

A/R LPS PROCYON BATCH: M17045

SAD 07-12-27 (2)

19.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

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Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0 D28061

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2806-1

Bushing

33590

AS 07/12/28

(2)

22.0 D28063

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2806-3

Bushing

B27286 3X  
BA9847 X1

AS 07/12/28

(2)

23.0 D28105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Strut

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2810-5

Strut

B32775 X1 B35829 X1

AS 07/12/28

(2)

24.0 D33961

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Spacer

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D3396-1

Spacer

34025

AS 07/12/28

(2)

25.0 AN4C6A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

M105793

AS 07/12/28

(2)

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Part Number: D412630034

Job Number:



Seq. #: Machine Or Operation:

Description :

1 AN4C6A Bolt

26.0 AN4C10A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)  
Bolt



Pick: Packing Kit

Qty Part Number Description Batch  
1 AN4C10A Bolt M101189

27.0 AN4C15A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)  
Bolt



Pick: Packing Kit

Qty Part Number Description Batch  
2 AN4C15A Bolt M103915

28.0 AN44C7A Eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)  
Eyebolt



Pick: Packing Kit

Qty Part Number Description Batch  
1 AN44-C7A Eyebolt M101711

29.0 AN5C15A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)  
Bolt

4

AS 07/12/28

x2

Pick: Packing Kit

Qty Part Number Description Batch  
2 AN5C15A Bolt M105125

AS 07/12/28

x2

30.0 NAS1515H4 Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 35.0000 Each(s)  
Washer

14



Pick: Packing Kit

Qty Part Number Description Batch  
7 NAS1515H4 Washer M105516

AS 07/12/28

x2

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Job Number: 33999

Part Number: D412630034

Job Number:



Seq. #: Machine Or Operation:

Description :

31.0 NAS1515H5 Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total: 35.0000 Each(s)

14

Washer

Pick: Packing Kit

Qty Part Number Description Batch

7 NAS1515H5 Washer

M105792



32.0 MS210434 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

8

Nut

Pick: Packing Kit

Qty Part Number Description Batch

4 MS21043-4 Nut

106421



33.0 MS210435 Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total: 15.0000 Each(s)

10

Nut

Pick: Packing Kit

Qty Part Number Description Batch

3 MS21043-5 Nut

105430



34.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

8/01/08 (2)

35.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-034

Location:

PPP Rev: A

8/1/10 sc (2) AS



36.0 QC21 FINAL INSPECTION/W/O RELEASE



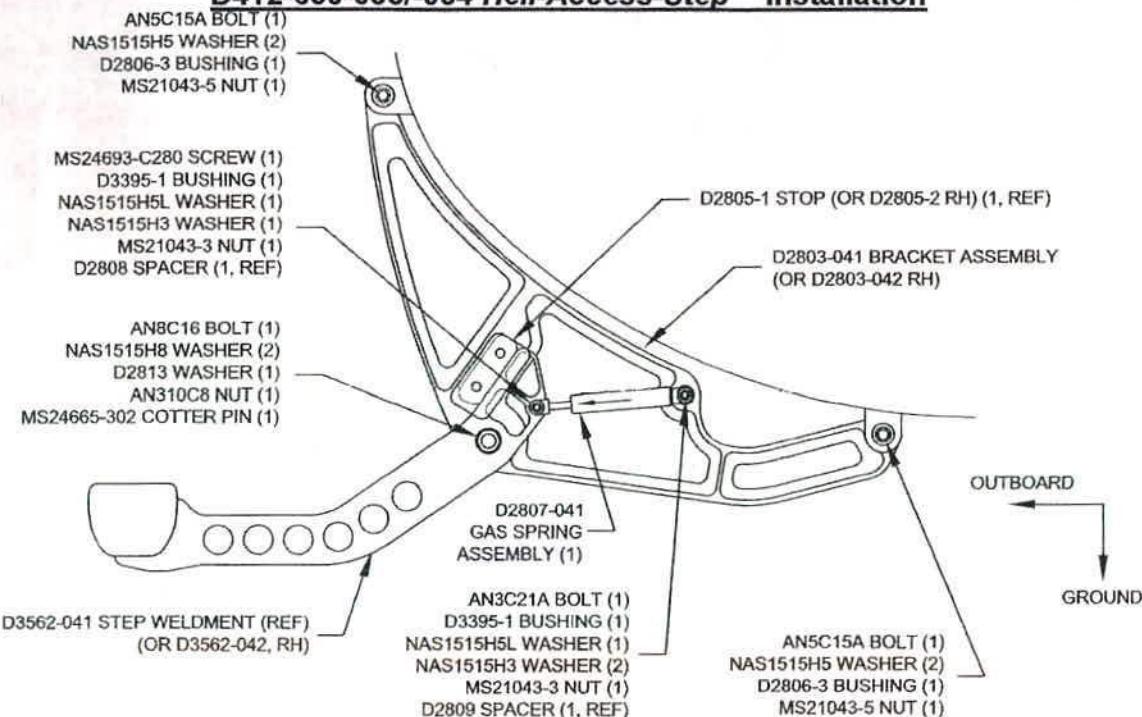
Comment: FINAL INSPECTION/W/O RELEASE



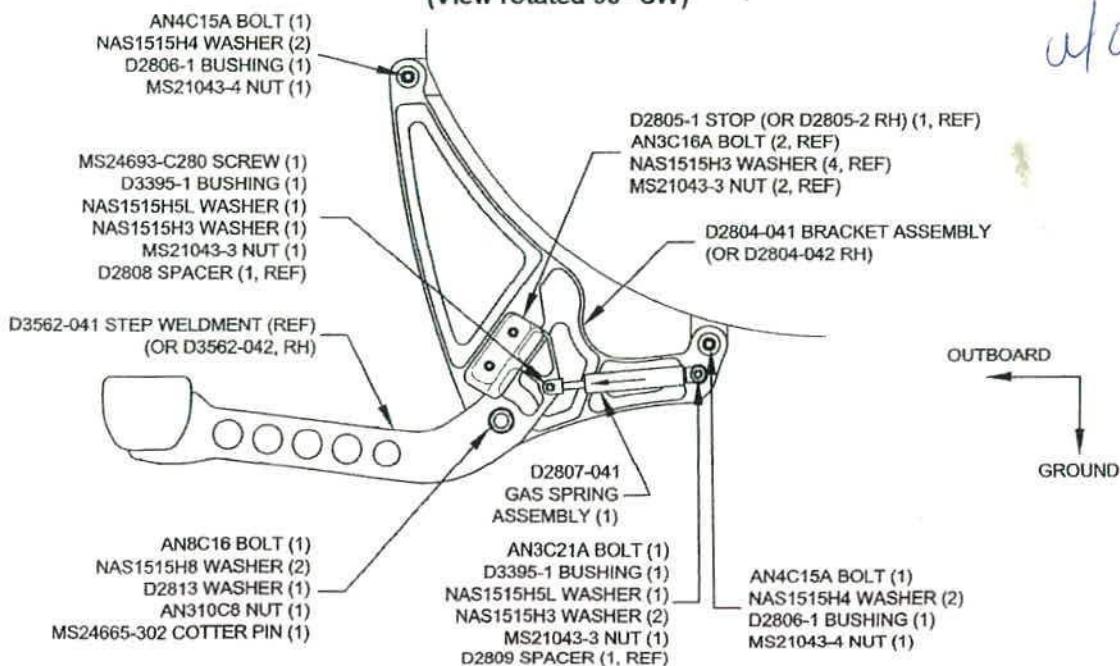
Job Completion



8/01/11 (2)

**D412-630-033/-034 Heli-Access-Step™ Installation**

**FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation**  
(View rotated 90° CW)



**FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation**  
(View rotated 90° CW)